

Date: Monday, 09/02/2009 4:28:39 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSEMBLY
Job Number :	45647		
Estimate Number :	13532		
P.O. Number :		Part Number :	PB674300103
This Issue :	09/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1,3,4,16 <i>19</i>
First Issue :	//	Project Number :	N/A
Previous Run :	45646	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	01/04/2009
Written By :		Qty:	2
Checked & Approved By :	<i>mf 09-03-10</i>	Um:	Each
Comment :	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300109	Aft Blade Fold Assembly Weldment
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Aft Blade Fold Assembly Weldment batch: <i>B45045</i> <i>mf 09-03-13</i>		
2.0	PB674300113	Aft Adjustable Blade Support Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Aft Adjustable Blade Support Assembly batch: <i>B45042</i> <i>mf 09-03-13</i>		
3.0	PB674300117	Aft Adjustable Blade Support Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Aft Adjustable Blade Support Assembly batch: <i>B45040</i> <i>mf 09-03-13</i>		
4.0	PB674300121	PB67-43001-21
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) PB67-43001-21 batch: <i>B45038</i> <i>mf 09-03-13</i>		
5.0	PB674300123	PB67-43001-23
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) PB67-43001-23 batch: <i>B45035</i> <i>mf 09-03-13</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:28:39 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45647

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300137

PB67-43001-37



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-37

batch: B45029

Cpl 09.03.13

7.0

PB674300157

Stabilizer Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Stabilizer Arm

batch: B45025

Cpl 09.03.13

8.0

PB674300159

PB67-43001-59



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-59

batch: B45024

Cpl 09.03.13

9.0

PB674300163

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Assembly

batch: B45023

Cpl 09.03.13

10.0

PB6743001135

Male Eye



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Male Eye

batch: B23995A

Cpl 09.03.13

11.0

PB6743001155

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

batch: B40577

Cpl 09.03.13

12.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lever Arm

batch: B44978

Cpl 09.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:28:39 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45647

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



Comment: Qty.: ~~5~~ 1.0000 Each(s)/Unit Total : ~~10~~ 1.0000 Each(s)

Bushing

batch: B44977

Pl09.03.13

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

batch: B40062 → 2 B43094 → 2

Pl09.03.13

15.0

PB6743001305

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bearing

batch: B41886

Pl09.03.13

16.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: B45309

Pl09.03.13

17.0

D3451043

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle and Lock-Down Assembly

batch: B45308

Pl09.03.13

18.0

D34401

Tube Guide (Supersedes B67-43001-25/-307)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube Guide

batch: B41347

Pl09.03.13

19.0

D34403

Clamp (Supersedes B67-43001-309)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

batch: B41277

Pl09.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:28:39 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45647

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Velcro Loop Belt

batch: B39965

Cpl 09-03-13

21.0

D34491

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pad

batch: B45257

Cpl 09-03-13

22.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Swing Arm

batch: B41352

Cpl 09-03-13

23.0

086004

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: M109350

Cpl 09-03-13

24.0

MS27039107

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M18057

Cpl 09-03-13

25.0

MS27039123

SCREW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch: M18057

Cpl 09-03-13

26.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Nut

batch: M109282

Cpl 09-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:28:39 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45647

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

27.0	MS21042L6	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: M108183

Cpl 09.03.13

28.0	MS518596	WASHER
------	----------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: M108473

Cpl 09.03.13

29.0	MS518598	WASHER
------	----------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: M108986 → 1 M111060 → 15

Cpl 09.03.13

30.0	NAS43DD368	SPACER
------	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SPACER

batch: M109060

Cpl 09.03.13

31.0	NAS1149F0316P	WASHER
------	---------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

batch: M11117

Cpl 09.03.13

32.0	NAS1149F0432P	Washer
------	---------------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch: M18057

Cpl 09.03.13

33.0	NAS1149F0632P	WASHER
------	---------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: M18057

Cpl 09.03.13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:28:40 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45647

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m18057

lpl09.03.13

35.0

AN960JD6

Washer



Comment: Qty.: ¹⁰50000 Each(s)/Unit Total : 20000 Each(s)

Washer

batch: m6085

lpl09.03.13

36.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: m107178

lpl09.03.13

37.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: m110865

lpl09.03.13

38.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: _____

* or AN415A (see engineering) batch: m110399

lpl09.03.13

39.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: m105558

lpl09.03.13

40.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: _____

or AN6116A (see engineering) batch: m111119

lpl09.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:28:40 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45647

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: M18180 → 1 M110915 → 3

Pl09.03.13

42.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

RIVET

batch: M109119

Pl09.03.13

43.0

CR3213405

cherry rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

cherry rivet M104214

batch: ~~4~~

Pl09.03.13

44.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: _____

or MS17984C410 (see engineering) batch: M109739

Pl09.03.13

45.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

PIN, QUICK RELEASE

batch: M108786

Pl09.03.13

46.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

LANYARD

batch: M17828

Pl09.03.13

47.0

30345T24

LANYARDS



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

LANYARDS

batch: M108973 → 4 M111039 → 2

Pl09.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/03/2009 1:42:00 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSEMBLY
Job Number :	45647		
Estimate Number :	13532		
P.O. Number :		Part Number :	PB674300103
This Issue :	10/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1,3,4,15
First Issue :	09/02/2009	Project Number :	N/A
Previous Run :	45646	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	01/04/2009
Written By :		Qty:	2
Checked & Approved By :	<u>mf 09-03-10</u>	Um:	Each
Comment :	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

50.0	MS24694S102	Screw
------	-------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Screw m14604



Pl09-03-13

51.0	AN526A	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 BOLT m18057



Pl09-03-13

52.0	MS1859-6	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Washer m108984



Pl09-03-13

53.0	NAS1149F0532P	WASHER
------	---------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
 WASHER m18057



Pl09-03-13

54.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Nut m110382



Pl09-03-13

Job Completion



Date: Monday, 09/02/2009 4:28:40 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45647

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

240107

SPRING SLOTTED PIN



Comment: Qty.: ¹²29.0000 Each(s)/Unit Total: ²⁴18.0000 Each(s)

SPRING SLOTTED PIN

batch: M111088

Cpl 09-03-13

49.0

3408A98

DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

DETENT BALL SPRING PLUNG

batch: M111078

Cpl 09-03-13

50.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: _____

N.A.

mf 09-03-12

Next Pass

51.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/16 (x2)

52.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPA 44664

C 4/3/12

53.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/17

Job Completion



mf 09-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/03/2009 7:52:39 AM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSEMBLY
Job Number	: 45647		
Estimate Number	: 13532		
P.O. Number	:	Part Number	: PB674300103
This Issue	: 12/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: B6743001 P.1,3,4,15
First Issue	: 09/02/2009	Project Number	: N/A
Previous Run	: 45646	Drawing Revision	: B1
		Material	:
Written By	:	Due Date	: 01/04/2009
Checked & Approved By	: <u>MF 09-03-14</u>	Qty:	2
Comment	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: M1109687



(x2)

09/03/14

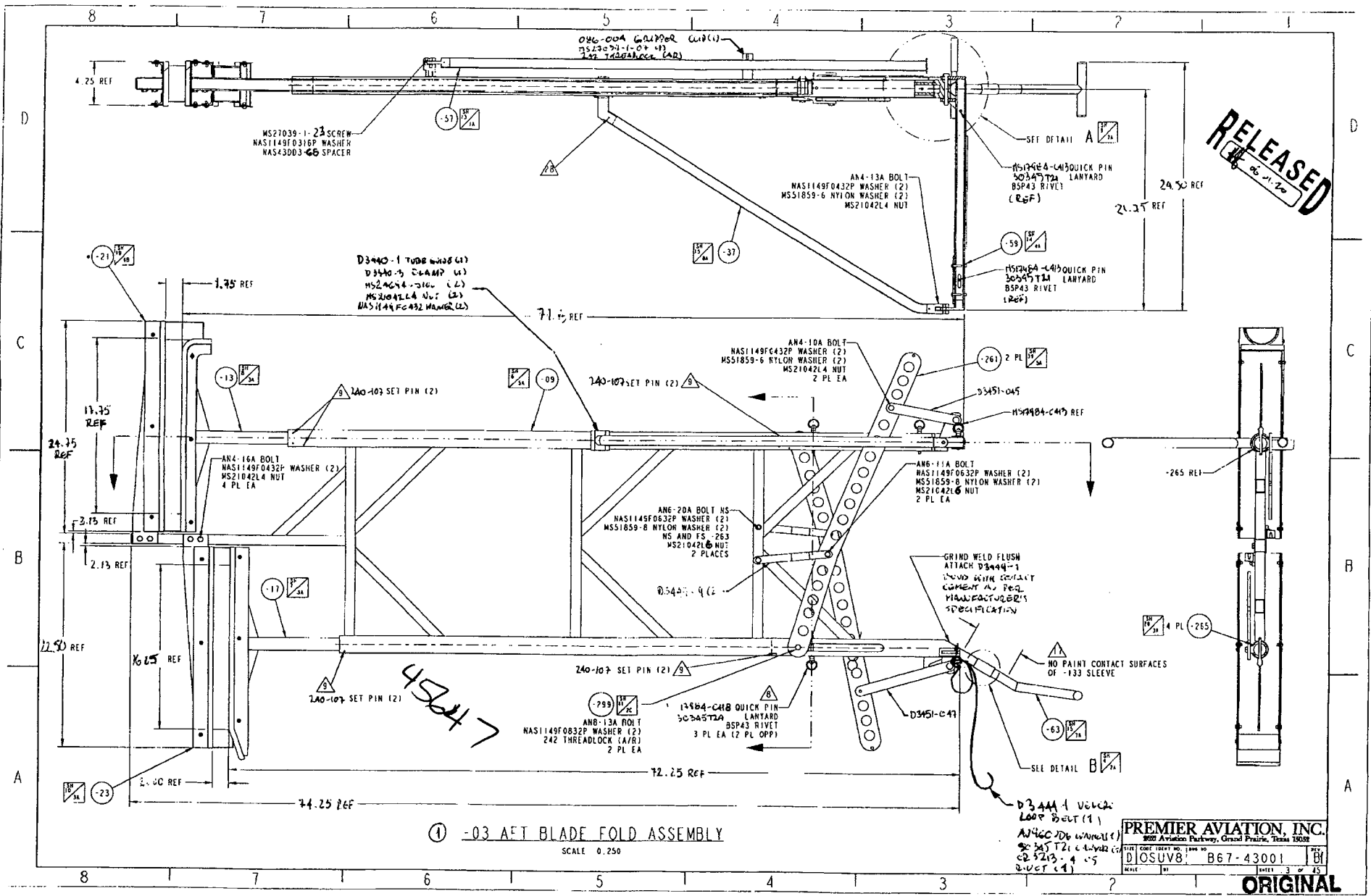
M.L.

Job Completion



45647

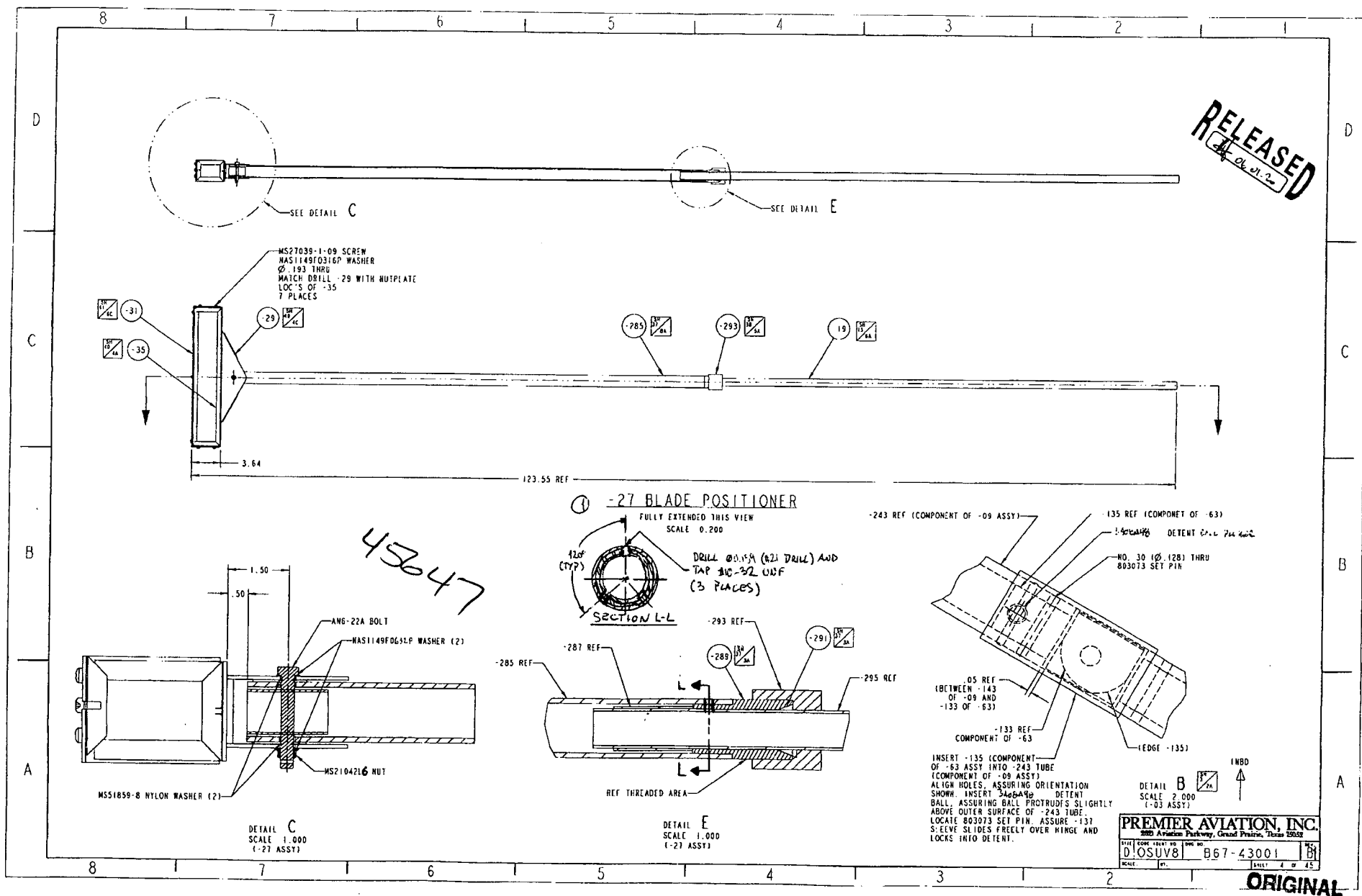
RELEASED



ORIGINAL

453647

RELEASED
46-21-2

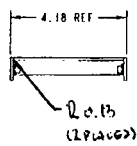
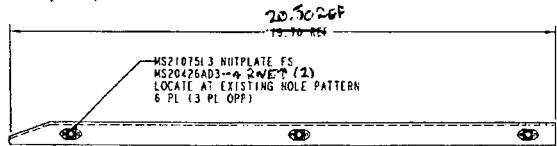
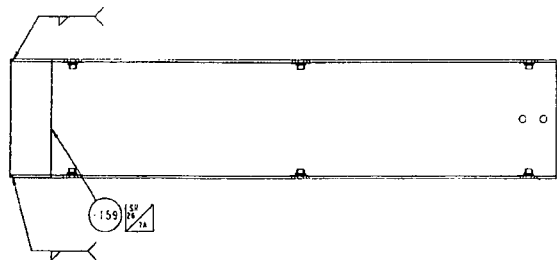


453647

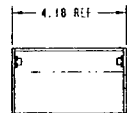
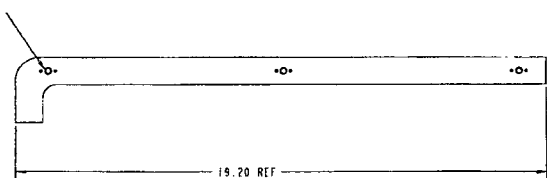
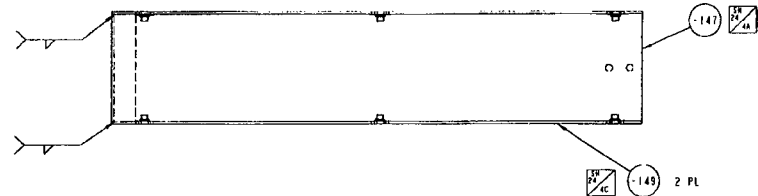
ORIGINAL

RELEASED

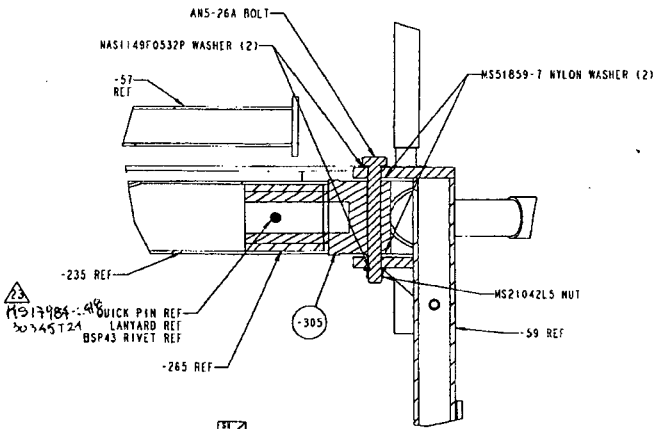
45247



② -71 20 DEGREE BLADE SUPPORT ASSEMBLY
SCALE 0.500



② -67 90 DEGREE BLADE SUPPORT ASSEMBLY
SCALE 0.500



DETAIL A
SCALE 0.750
(-03 ASSY)